

Date: Thursday, 3/13/2008 10:19:08 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services		Drawing Name	SADDLE FITTING, FWD (OUTBOARD/INBOARD)		
Job Number	37922		Part Number	D2572		
Estimate Number	10531		Drawing Number	D2572 REV E		
P.O. Number			Project Number	N/A		
This Issue	3/13/2008	S.O. No. :	Drawing Revision	E		
Prsht Rev.	NC		Material			
First Issue	/ /	Type :	Due Date	4/4/2008	Qty:	10
Previous Run	37565		Um:	Each		
Written By						
Checked & Approved By	<u>DP 08/03/13</u>					
Comment	Est: 1 02.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	D6101005	7075-T7351 8.25X5.0X2.5	
Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s) 7075-T7351 8.25X5.0X2.5 Make from D6101-005 billet for D2572 Ensure that grain is along 5.00" length Batch No: <u>R34274</u>			
2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1	

Comment: HAAS CNC VERTICAL MACHINING #1
 Program Batch No. 37922 Double check by: DP

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

On 08/03/08

10

3.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE	
Comment: CONVENTIONAL MILLING MACHINE Machine keyway as per dwg D2571 & D2572			
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
Comment: INSPECT PARTS AS THEY COME OFF MACHINE			

On 08/04/08J.L 08/04/08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 37922

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 QC8 SECOND CHECK



Comment: SECOND CHECK

8F 08/04/02

6.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



10X

Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

M-1

08/04/02

7.0 POWDER COATING POWDER COATING



M 107550



10.

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

16K 08-04-03

8.0 QC3 INSPECT POWDER COAT/CHEMICAL CONVERSION



AS

AS. 08-04-03

X10

Comment: INSPECT POWDER COAT

9.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

AS 08/04/04 X10

10.0 QC21 FINAL INSPECTION/W/O RELEASE



08/04/08/04

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



108.04.04

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	37922
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				1	2	3	4		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.001	8.001		
F	0.490	0.510		.502	.502	.507	.502		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.499	.499	.500		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.570	.569	.565	.568		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.496	1.495		
N	2.495	2.505		2.500	2.499	2.499	2.500		
O	3.869	3.879		3.871	3.873	3.872	3.873		
P	0.115	0.135		.126	.129	.126	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.249	.254	.252	.251		
S	0.115	0.135		.130	.132	.133	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.966	2.960	2.960		
V	0.230	0.250		.237	.235	.236	.235		
W	0.115	0.135		.125	.135	.127	.129		
X	0.307	0.312		.309	.309	.308	.308		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.358	.369	.355	.361		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.623	.623	.626	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.245	.243	.246	.246		
AE	1.375	1.395		1.387	1.392	1.387	1.387		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.266	.255	.255	.259		
AH	0.240	0.260		.267	.245	.247	.245		
AI	2.000	2.020		2.001	2.005	2.000	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: *Mark J.L.*
Date: 08/04/02

Audited by: *8-5*
Date: 08/04/02

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM <i>RF</i>	<i>JLM</i>

DART AEROSPACE LTD				Work Order:	37R22
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

Dim	Min	Max	Go/No Go Gauge	Recorded Actual Dimensions				By	Date
				15	26	37	48		
A	0.438	0.443		.440	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.001	8.001	8.001	8.001		
F	0.490	0.510		.503	.502	.504	.501		
G	0.257	0.262		.260	.260	.260	.260		
H	0.375	0.380		.378	.378	.378	.378		
I	0.490	0.510		.499	.502	.501	.502		
J	1.174	1.184		1.178	1.179	1.179	1.179		
K	0.558	0.578		.576	.572	.569	.570		
L	1.174	1.184		1.178	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.872	3.874	3.874	3.874		
P	0.115	0.135		.126	.125	.125	.125		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.257	.250	.250	.250		
S	0.115	0.135		.136	.129	.126	.125		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.959	2.958	2.958	2.958		
V	0.230	0.250		.235	.237	.237	.236		
W	0.115	0.135		.127	.127	.124	.123		
X	0.307	0.312		.309	.309	.309	.309		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.362	.360	.362	.362		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.622	.623	.621	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.246	.248	.246	.244		
AE	1.375	1.395		1.387	1.391	1.390	1.390		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.266	.260	.260	.260		
AH	0.240	0.260		.247	.245	.248	.246		
AI	2.000	2.020		2.000	2.004	2.003	2.002		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by: QML / J.L
Date: 08/04/01

Audited by: JK
Date: 08/04/01

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B	02.09.24	Re-format; Added Rev. D	KJ	
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B	1.745	1.755		1.750	1.750				
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G	0.257	0.262		.260	.260				
H	0.375	0.380		.378	.378				
I	0.490	0.510		.502	.502				
J	1.174	1.184		1.179	1.179				
K	0.558	0.578		.564	.570				
L	1.174	1.184		1.179	1.179				
M	1.490	1.500		1.500	1.500				
N	2.495	2.505		2.500	2.500				
O	3.869	3.879		3.874	3.874				
P	0.115	0.135		.124	.124				
Q	0.115	0.135		.135	.135				
R	0.240	0.260		.250	.249				
S	0.115	0.135		.126	.124				
T	0.178	0.198		.188	.188				
U	2.940	2.980		2.958	2.958				
V	0.230	0.250		.238	.238				
W	0.115	0.135		.126	.125				
X	0.307	0.312		.309	.309				
Y	0.760	0.765		.760	.760				
Z	0.352	0.372		.360	.360				
AA	0.470	0.530		.500	.500				
AB	0.615	0.635		.622	.623				
AC	0.053	0.073		.063	.063				
AD	0.240	0.260		.241	.242				
AE	1.375	1.395		1.389	1.389				
AF	0.115	0.135		.135	.135				
AG	0.240	0.280		.260	.260				
AH	0.240	0.260		.246	.247				
AI	2.000	2.020		2.002	2.002				
AJ	0.023	0.043		.033	.033				
Accept/Reject									

Measured by:	JL	Audited by:	RF
Date:	08/04/02	Date:	08/04/02

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